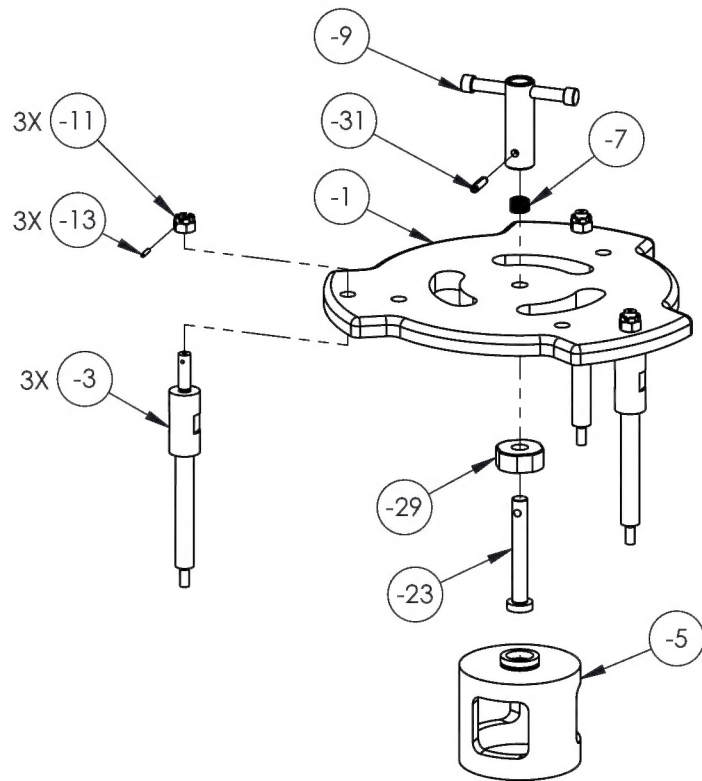
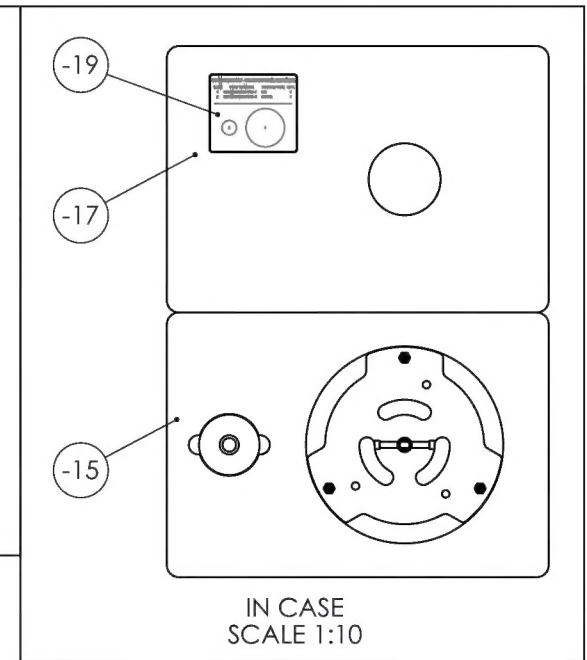
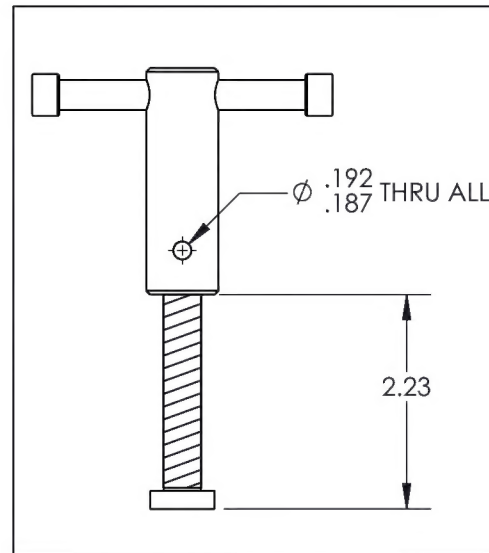


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	1/7/2016	DPD	JAG
2	16-0049	-1 REDESIGNED ADDED FEATURE Ø1.38 \pm .11. -3 CH'D DIM WAS 1.59 IS 1.69. -5 CH'D DESIGN DELETED 1/4-28 UNF -28 LH \pm .09, DELETED DETAIL B, ADDED DIM Ø.710 +.005 -.000 \pm .20. ADDED THREAD CALLOUT 1-12 UNF -2A, CH'D DIM WAS 3.03 IS 2.89. -9 CH'D P/N WAS CLM-1050-BHS IS CLM-10-BHN. -15 & -17 CH'D CUTOUT FOR REDESIGNED TOOL. -19 CH'D TOOL DESIGN, DELETED RBEM653V3004101-9. -23, -25, -27 & -29 ADDED PART & DWG. -31 ADDED TO BOM.	3/10/2016	RJC	JAG
3	16-0086	-1 CH'D DIM WAS R.20 IS R.19. -15 ADDED FINGER GRABS. -23 ADDED SEPERATE WELDMENT AND MACHINING SKETCHES. ADDED GD&T LIMITS. -27 CH'D DIM WAS .19 IS .25. -29 ADDED WRENCH FLATS.	7/21/2016	SM	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	LID	6061		2
			-3	3	STUD	4140/4142		3
			-5	1	GUIDE	4140/4142		4
		B/O	-7	1	THREADED INSERT	S.S.	M10 X 1.5 X 10mm (MCMASTER-CARR #91732A648)	1
		B/O	-9	1	BAR-HANDLE NUT	STEEL	M10 (CARR-LANE #CLM-10-BHN)	1
		B/O	-11	3	SLOTTED NUT	STEEL	M8 X 1.25, CLASS 8 (MCMASTER-CARR #93760A222)	1
		B/O	-13	3	SPRING PIN	S.S.	M2 X 12mm (MCMASTER-CARR #91610A206)	1
		B/O	-15	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	7.88 X 13.79 X 19.88 (CASE SOLUTIONS)	5
		B/O	-17	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.78 X 13.88 X 19.88 (CASE SOLUTIONS)	6
			-19	1	CONTENTS PLACARD	PLASTIC	1/16 X 4 X 4-1/2	7
		B/O	-21	1	CASE	PLASTIC	PELICAN #APP-IM2620-E	N/S
	X		-23	1	FOOT WELDMENT			8
	1		-25		STUD	STEEL	M10X1.5 X 80mm 10.9 (MCMASTER-CARR #94595A222) MOD.	9
	1		-27		FOOT	4140/4142 Q & T		10
			-29	1	CAP	4140/4142 Q & T		11
			-31	1	SLOTTED SPRING PIN	STEEL	Ø3/16 X 3/4 (MCMASTER-CARR #90692A723)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

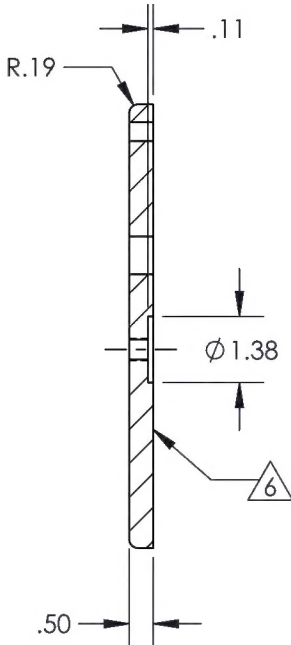
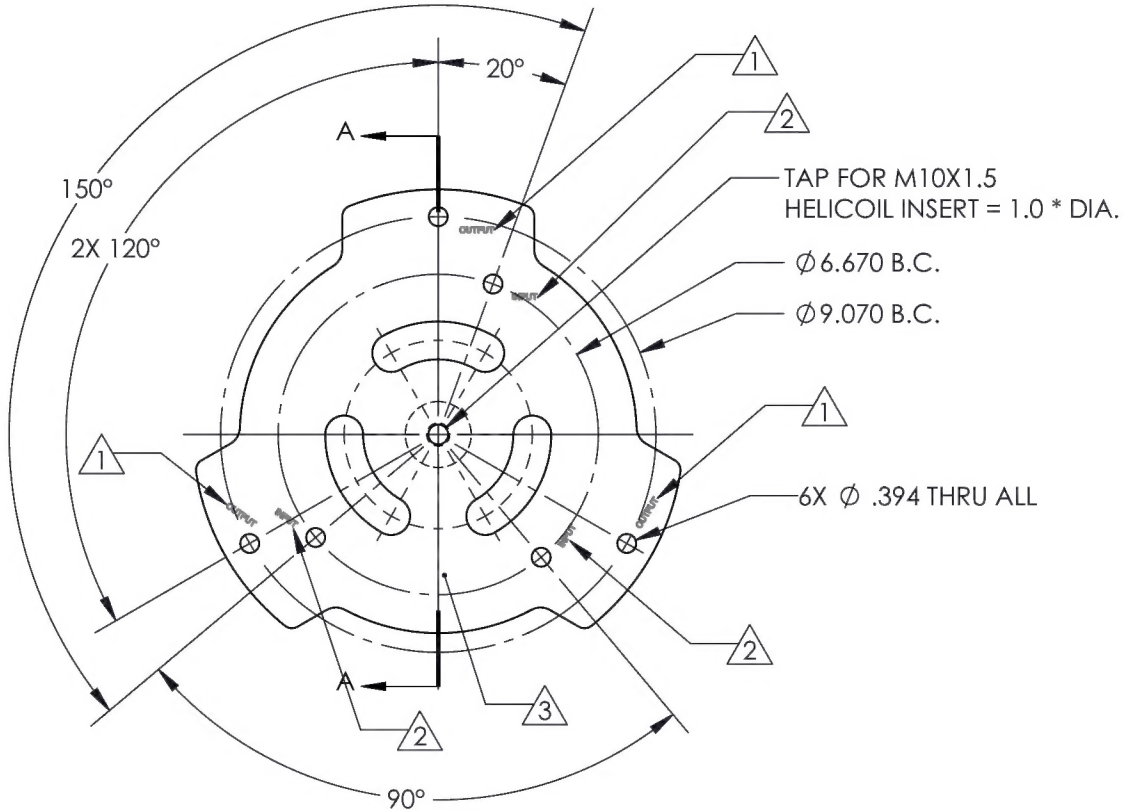
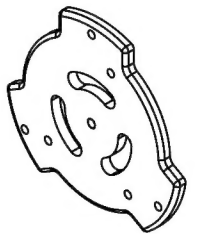
NOTE:
REF. AIRBUS T/N: M653V3004101.



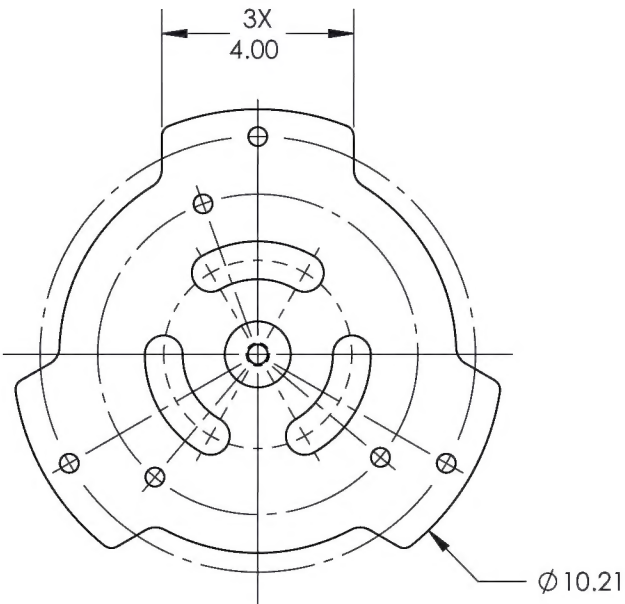
TITLE		IGB OUTPUT SEAL EXCHANGE	
DWG NO.		RBEM653V3004101	
REV		3	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX \pm .005 FRACTIONS \pm 1/8	
SPEC		.XX \pm .01 ANGLES \pm 5°	
DRAWN BY:		DUERFELDT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		J Gilbert	
SCALE		1:5	
DATE		12/1/2015	
SHEET		1 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	•1 REDESIGNED ADDED FEATURE Ø1.38 ▽.11.	3/10/2016	RJC	JAG
3	16-0086	•1 CH'D DIM WAS R.20 IS R.19.	7/21/2016	SM	JAG



SECTION A-A



NOTES:

- ① MACHINE ENGRAVE "OUTPUT", FILL WITH INK.
- ② MACHINE ENGRAVE "INPUT", FILL WITH INK.
- ③ INK STAMP T/N, S/N, "MADE IN USA"
4. USE CAD DATA TO MANUFACTURE.
5. DUAL FINISH:
 - 1ST. CLEAR ANODIZE, MIL-A-8625, TYPE II, CLASS I.
 - 2ND. POWDER COAT YELLOW, FED #13538.
- ⑥ NO POWDER COAT THIS SURFACE.



TITLE IGB OUTPUT SEAL EXCHANGE

DWG NO. RBEM653V3004101-1

MAT'L 6061	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	DIMENSIONS ARE IN INCHES	
FINISH SEE NOTE 5	.XXX ± .005	FRACTIONS ± 1/8
	.XX ± .01	ANGLES ± .5°
SPEC	.X ± .1	SURFACES = 125 ✓
	1. BREAK ALL SHARP EDGES	

DRAWN BY:	DUERFELDT	.015 x 45° OR .015R
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

QA APPR:	LINDSAY	USED ON M
APPROVED:	J Gilbert	H175

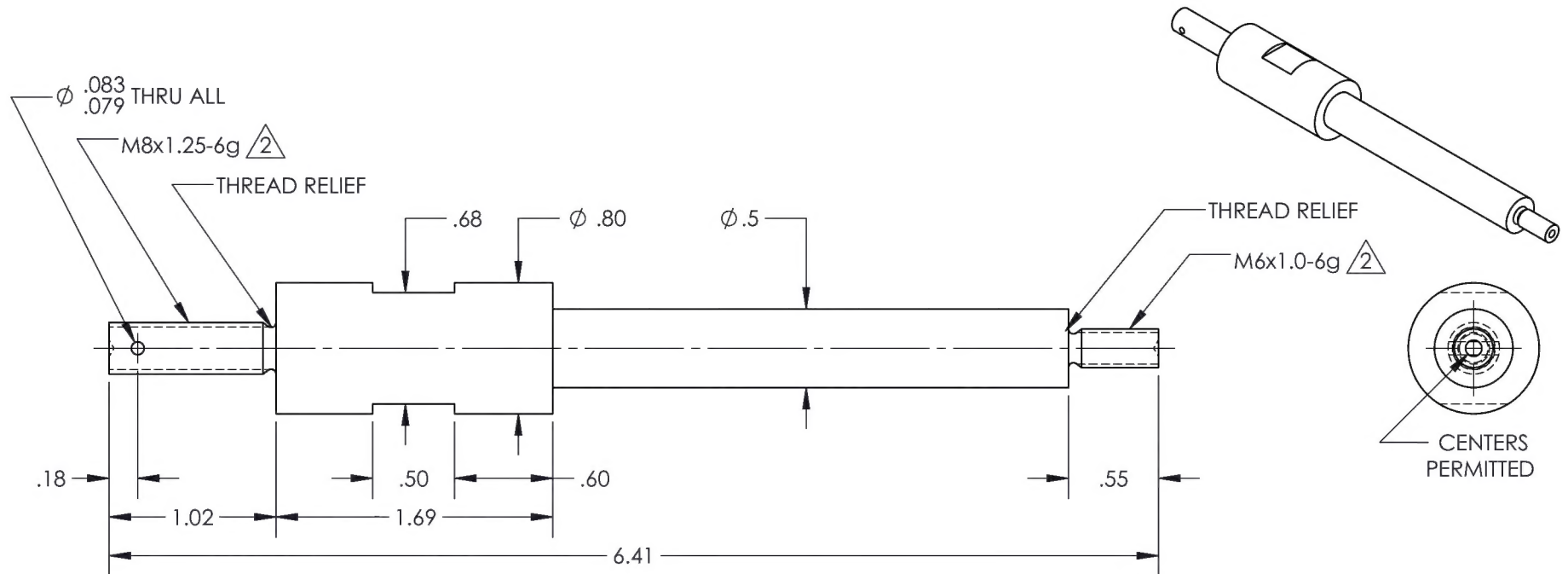
SCALE	1:4	DATE	12/1/2015	SHEET 2 OF 11
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①

LID

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-3 CH'D DIM WAS 1.59 IS 1.69.	3/10/2016	RJC	JAG



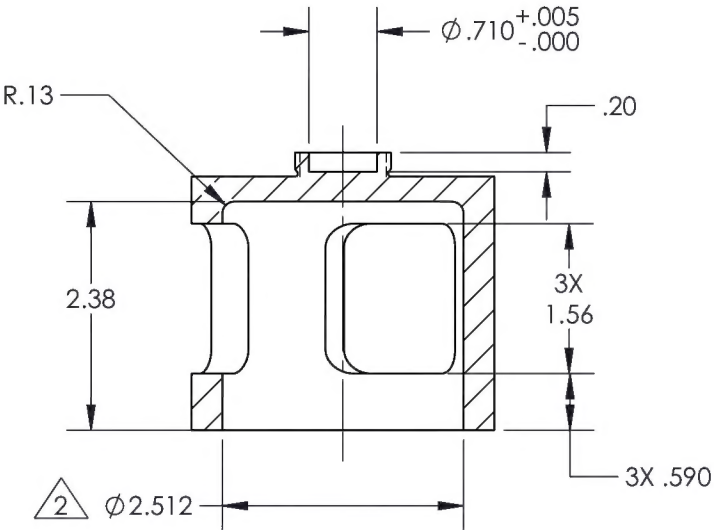
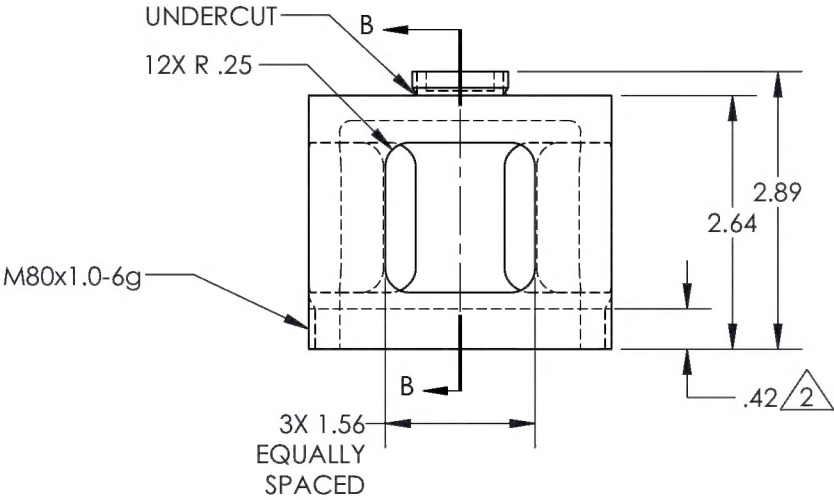
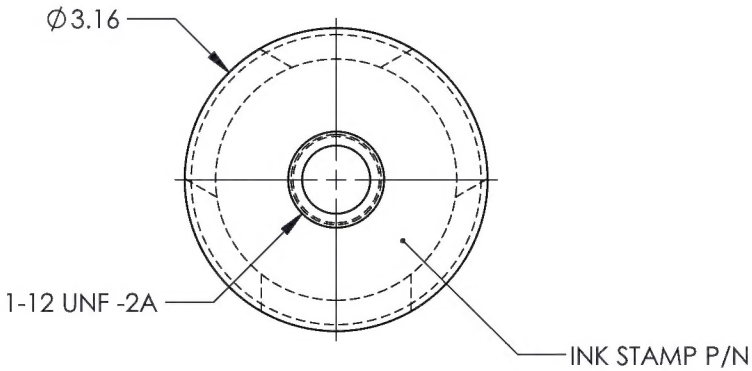
- NOTES:
- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE 1 SC2.
2ND: POWDER COAT YELLOW, FED #13538.
 - NO POWDER COAT THIS SURFACE.

(-3)
STUD

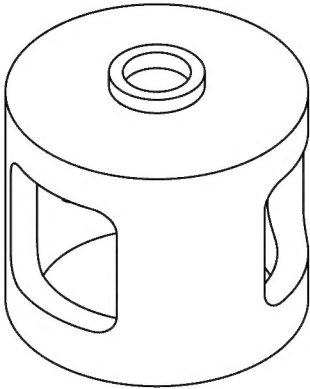
DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-3	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE NOTE 1	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125 ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 12/1/2015
SHEET 3 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-5 CH'D DESIGN DELETED 1/4-28 UNF -2B LH ∇ .09, DELETED DETAIL B, ADDED DIM \varnothing .710 \pm .005 \pm .000 ∇ .20. ADDED THREAD CALLOUT 1-12 UNF -2A. CH'D DIM WAS 3.03 IS 2.89.	3/10/2016	RJC	JAG



SECTION B-B

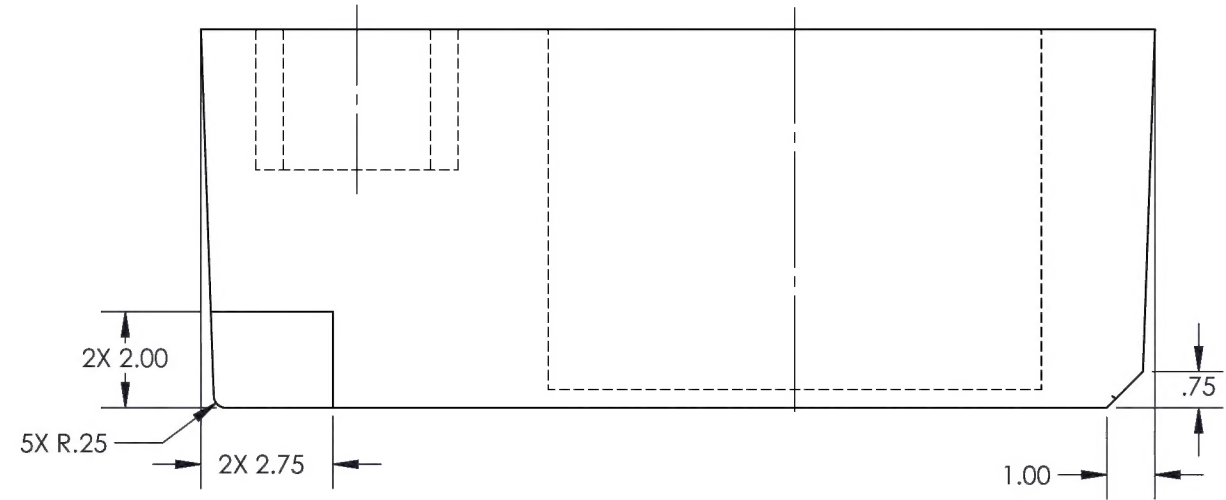
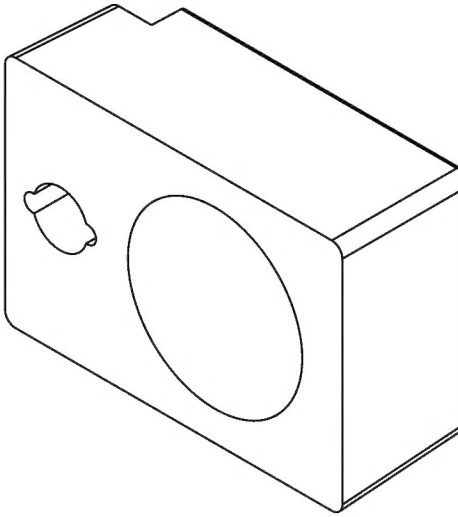
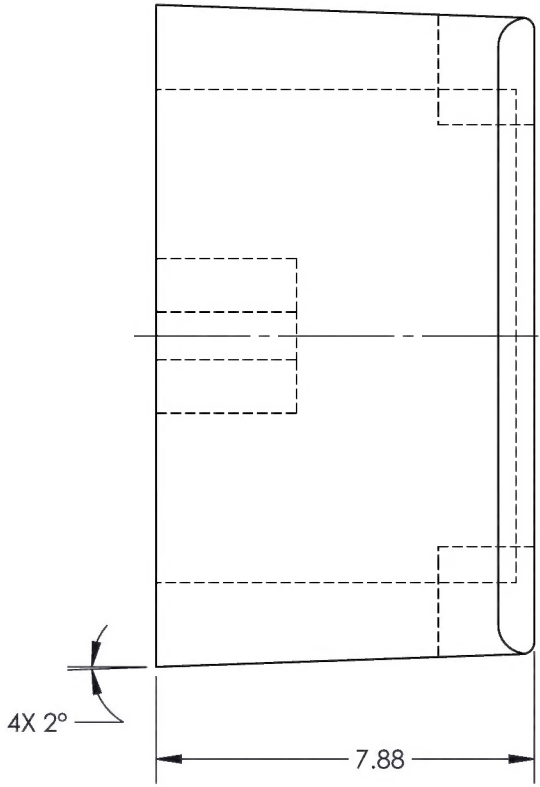
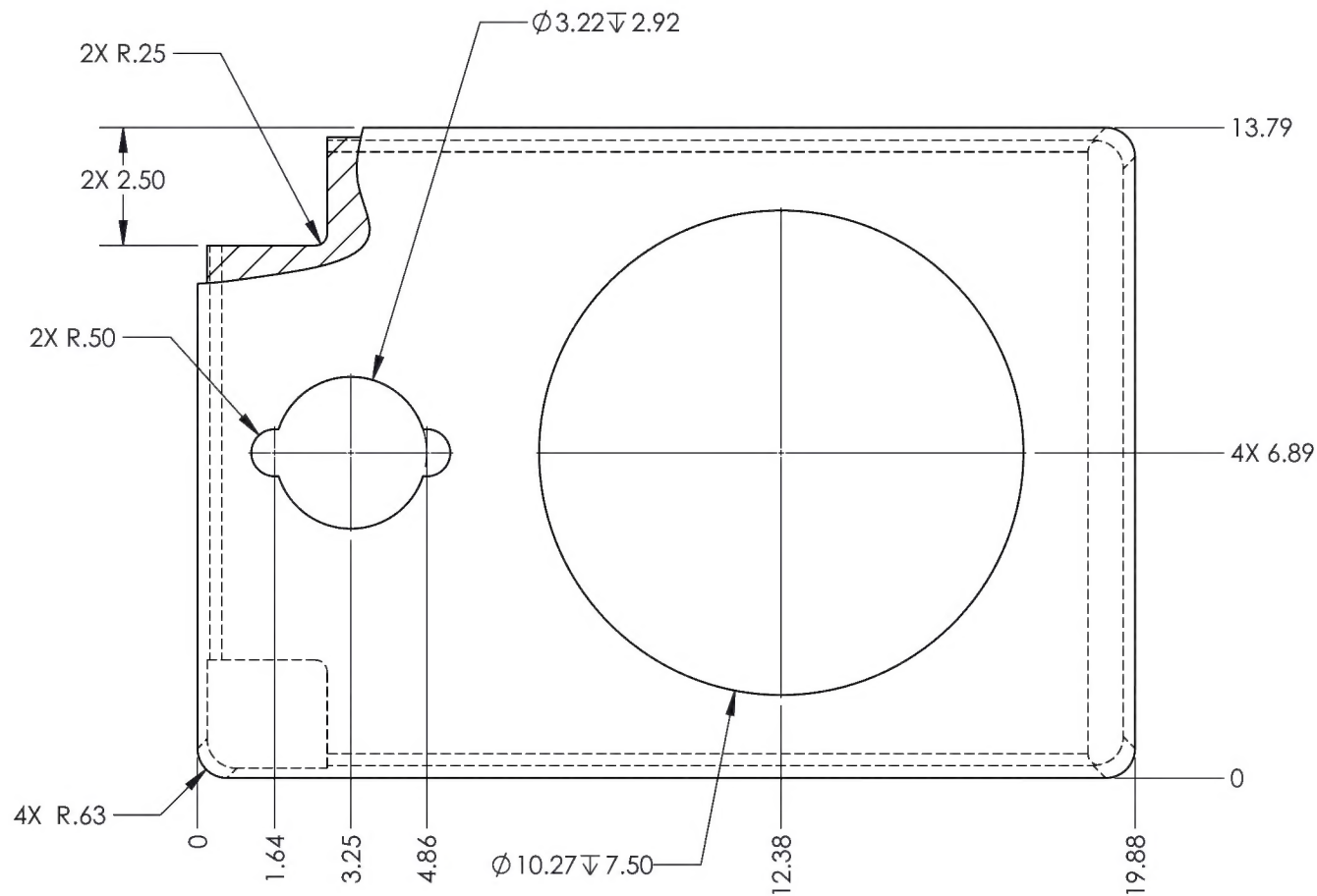


- NOTES:
- DUAL FINISH:
1ST: ZINC PLATE, ASTM B633 TYPE 1 SC2.
2ND: POWDER COAT YELLOW, FED #13538.
 - NO POWDER COAT THIS SURFACE.

DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-5	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH SEE NOTE 1	.XX \pm .01 ANGLES \pm 5°
SPEC	.X \pm .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 12/1/2015
SHEET 4 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-15 CH'D CUTOUT FOR REDESIGNED TOOL.	3/10/2016	RJC	JAG
3	16-0086	-15 ADDED FINGER GRABS.	7/21/2016	SM	JAG



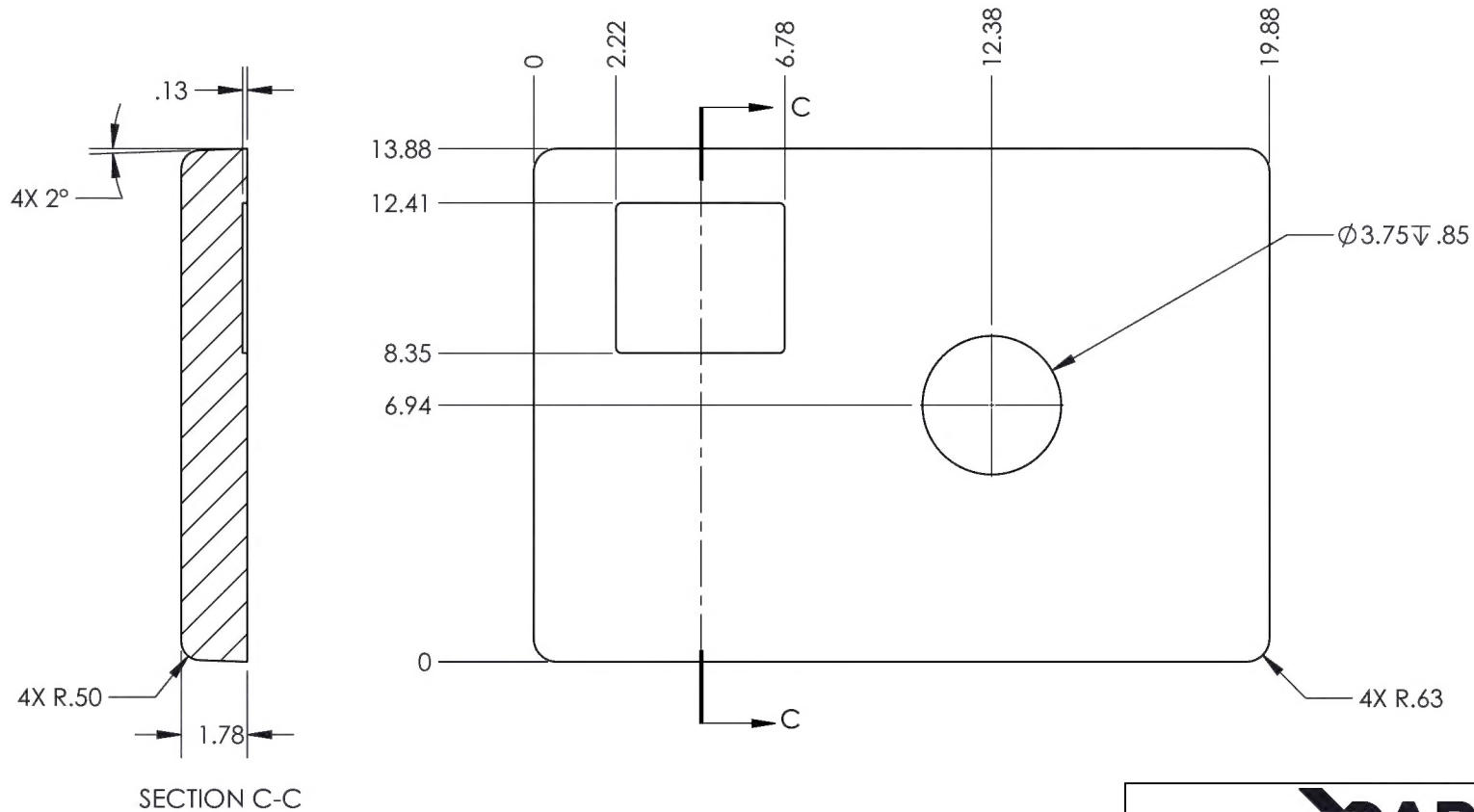
-15

BOTTOM TOOL CUSHION

DART AEROSPACE			
TITLE IGB OUTPUT SEAL EXCHANGE			
DWG NO. RBEM653V3004101-15			REV 3
MAT'L ETHAFOAM 220, BLACK		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH		.015 ± .003 ANGLES ± 1°	
SPEC		X ± .1 SURFACES = 125	
DRAWN BY:		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
APPROVED:		H175	
SCALE		DATE	SHEET 5 OF 11
1:4		12/1/2015	

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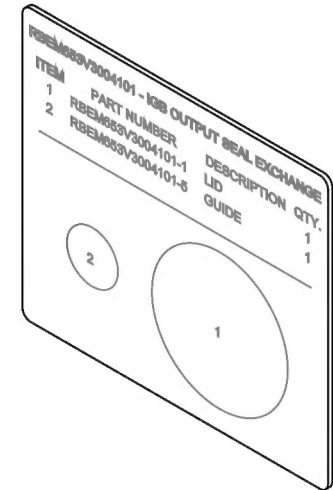
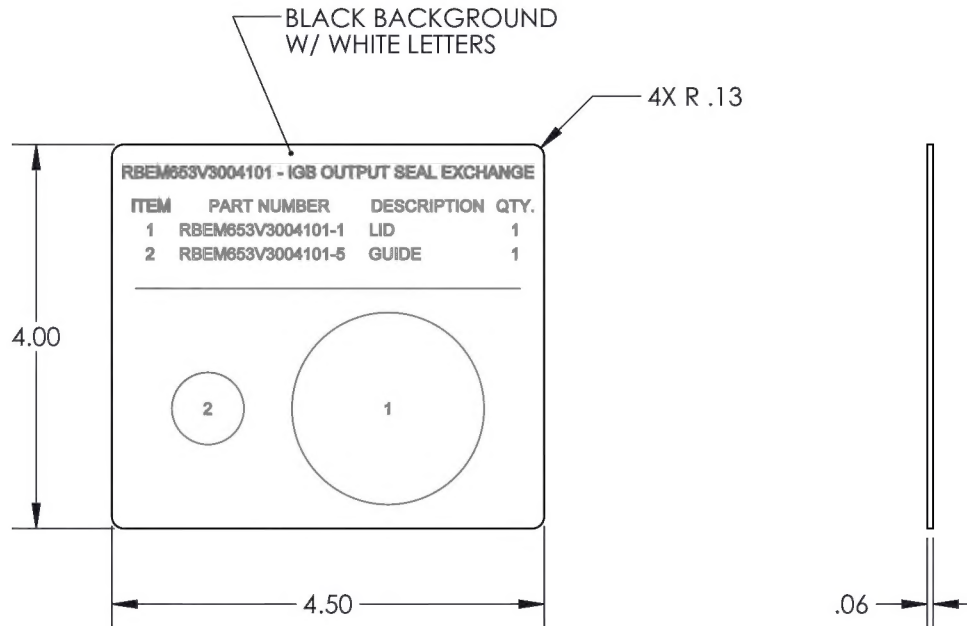
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-17 CH'D CUTOUT FOR REDESIGNED TOOL.	3/11/2016	RJC	JAG



DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-17	REV 2
MAT'L ETHAFOAM 220, BLACK	
TREAT	
FINISH	
SPEC	
DRAWN BY: DUERFELDT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:5	DATE 12/1/2015
SHEET 6 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-19 CH'D TOOL DESIGN, DELETED RBEM653V3004101-9.	3/11/2016	RJC	JAG



NOTE:
USE PDF.

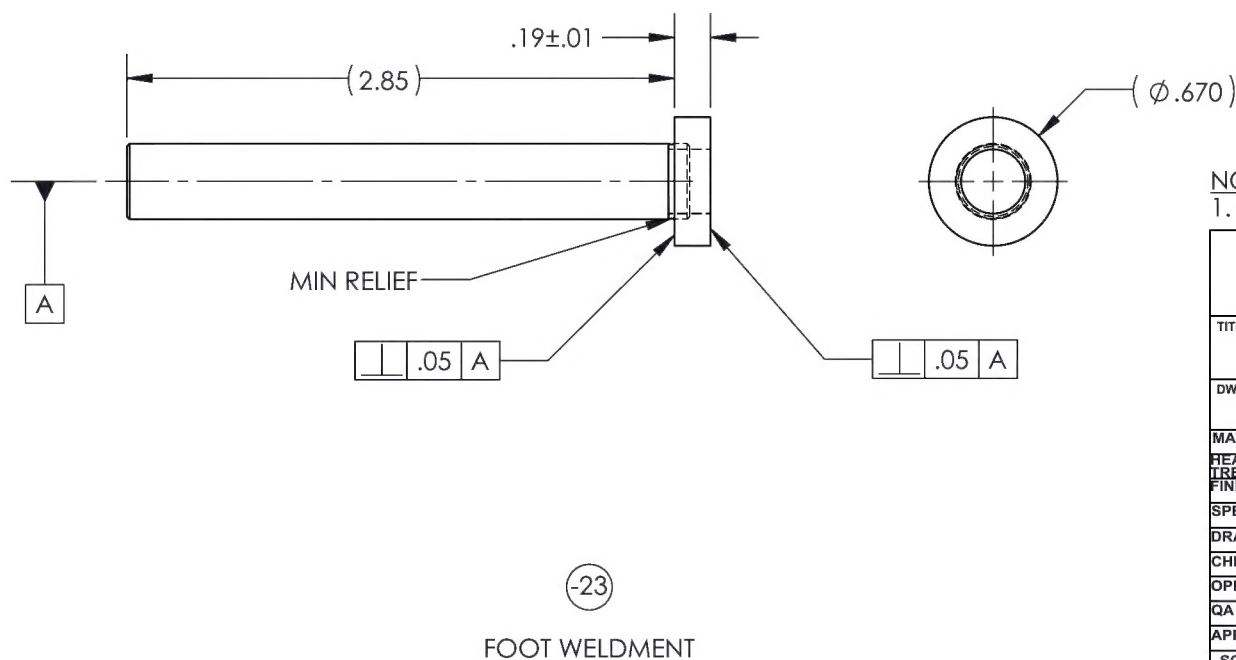
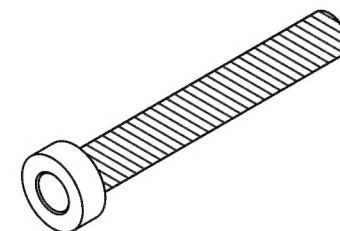
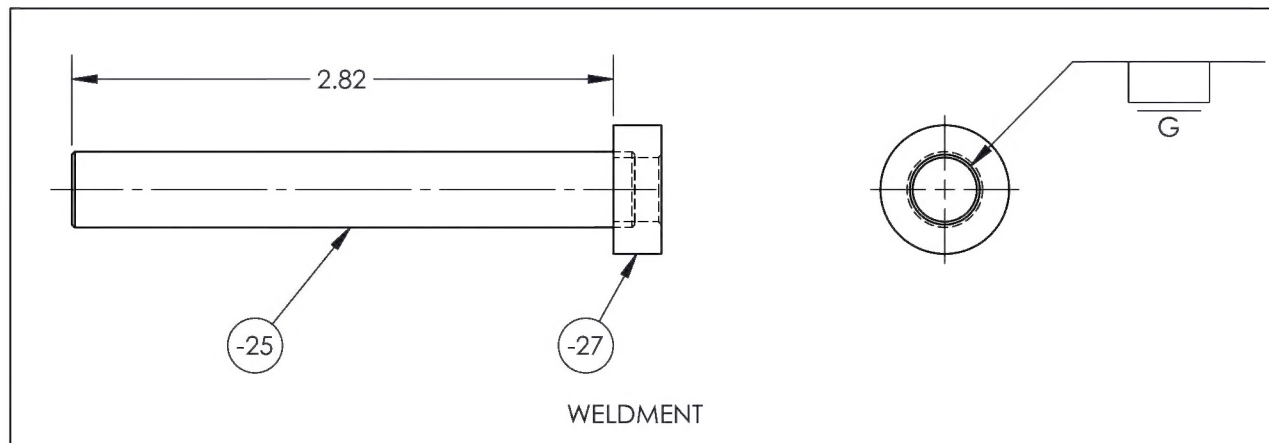
(-19)

CONTENTS PLACARD

DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-19	REV 2
MAT'L PLASTIC REAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:2	DATE 12/1/2015
SHEET 7 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-23 ADDED PART & DWG.	3/10/2016	RJC	JAG
3	16-0086	-23 ADDED SEPERATE WELDMENT AND MACHINING SKETCHES. ADDED GD&T LIMITS.	7/21/2016	SM	JAG

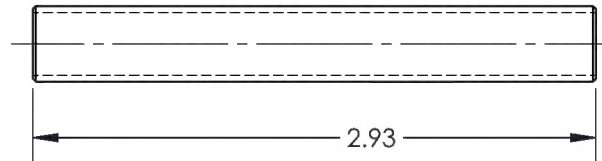
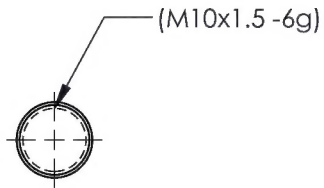
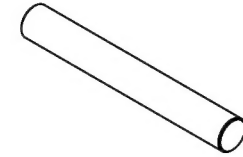


NOTES:
1. COMPLETE WELDMENT BEFORE MACHINING.

DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-23	REV 3
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125
HEAT TREAT ZINC PLATE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:1	DATE 3/10/2016
SHEET 8 OF 11	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-25 ADDED PART & DWG.	3/10/2016	RJC	JAG

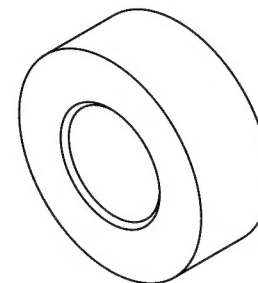
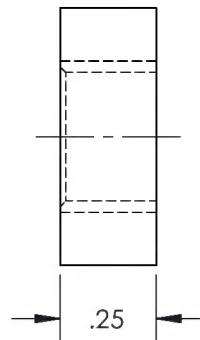
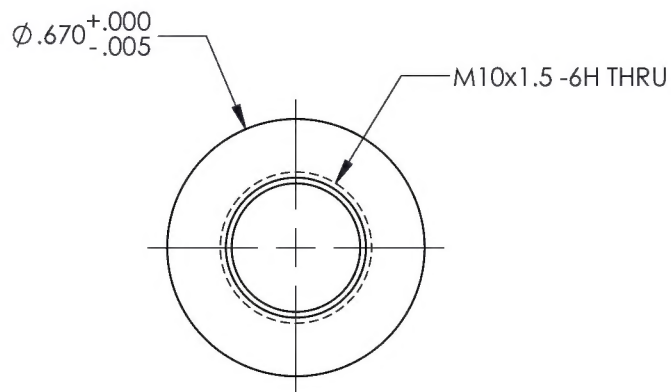


(-25)
STUD

DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-25	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 3/9/2016
	SHEET 9 OF 11

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-27 ADDED PART & DWG.	3/10/2016	RJC	JAG
3	16-0086	-27 CH'D DIM WAS .19 IS .25.	7/21/2016	SM	JAG



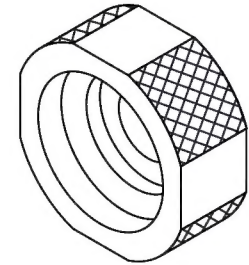
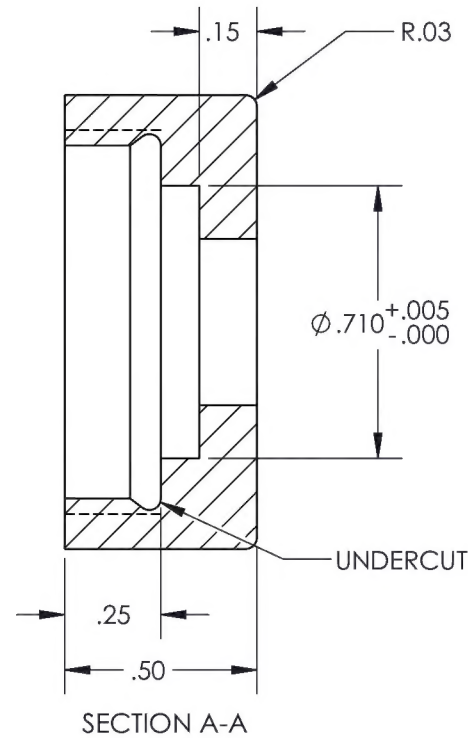
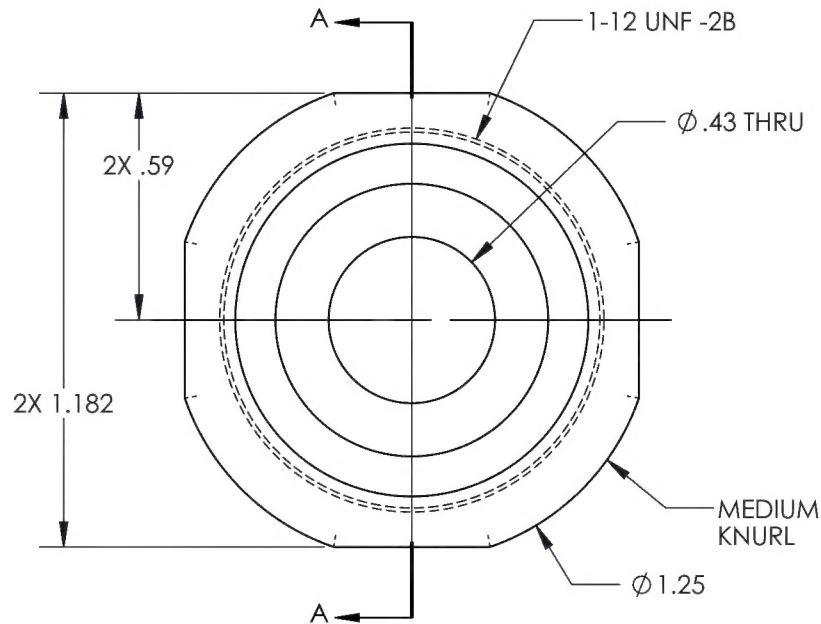
(-27)

FOOT

DART AEROSPACE	
TITLE IGB OUTPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-27	REV 3
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -23	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 3/9/2016
	SHEET 10 OF 11

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0049	-29 ADDED PART & DWG.	3/10/2016	RJC	JAG
3	16-0086	-29 ADDED WRENCH FLATS.	7/21/2016	SM	JAG



(-29)

CAP

DART AEROSPACE	
TITLE TGB INPUT SEAL EXCHANGE	
DWG NO. RBEM653V3004101-29	REV 3
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC ASTM B633 TYPE I SC 2	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: CLOUGH	.X \pm .1 SURFACES = 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 12/1/2015	USED ON MODEL
SHEET 11 OF 11	H175